

Work Order ID 67222



Page 1

Friday, March 11, 2011 9:54:22 AM

Item ID: D3065-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Leg

Start Date: 3/11/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 80.00



Customer:

Reference:

Run Start



Approvals: Process Plan: [Signature] Date: _____ Tooling: _____ Date: _____

QC: [Signature] Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D I Dwg Rev: B I Prog Rev: B I I2-Deburr if necessary

AB 11-3-21

(80)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

AB 11-3-21

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sub 123

count
(80)
asp 015

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID

Friday, March 11, 2011

Item ID: D306

Revision ID:

Item Name: Step 1

Start Date: 3/11/2011

Required Date: 3/18/2011

Reference:

Approvals: Proc

QC:

Sequence ID/
Work Center ID

160



QC

Quality Control

Work Order ID 67222

Friday, March 11, 2011 9:54:22 AM

Item ID: D3065-5

Revision ID:

Item Name: Step Leg

Start Date: 3/11/2011 Start Qty: 80.00

Required Date: 3/18/2011 Req'd Qty: 80.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

130



HandFinish

Hand Finishing

Operation
Description

Chemical Conversion Coat per QSI005 4.1

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location GA

Memo

0.00

0.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



80x M-L 11/03/23

80x M-L 11/03/23

SB 11/03/23

80

W/O:	
DATE	STEP

Part No: _____

Res

NCR:	
DATE	STEP

NOTE: Date & initial

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, March 11, 2011 9:54:19 AM

Page 1
1

Work Order ID: 67222



Parent Item: D3065-5



Parent Item Name: Step Leg

Start Date: 3/11/2011

Required Date: 3/18/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP: FIC1102.11.01 Incorporated D3066-1 IPP[KJ/RF
IPP Rev:D Now on Water Jet 06-04-11 JLM
IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.080

Purchased

No

100

sf

187.7000

0.825

69.47368



1811-3-21

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT

187.7

116268

52.6

116700

135.1

116700

80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 67222
Description: Step Leg		Part Number: D3065-5
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

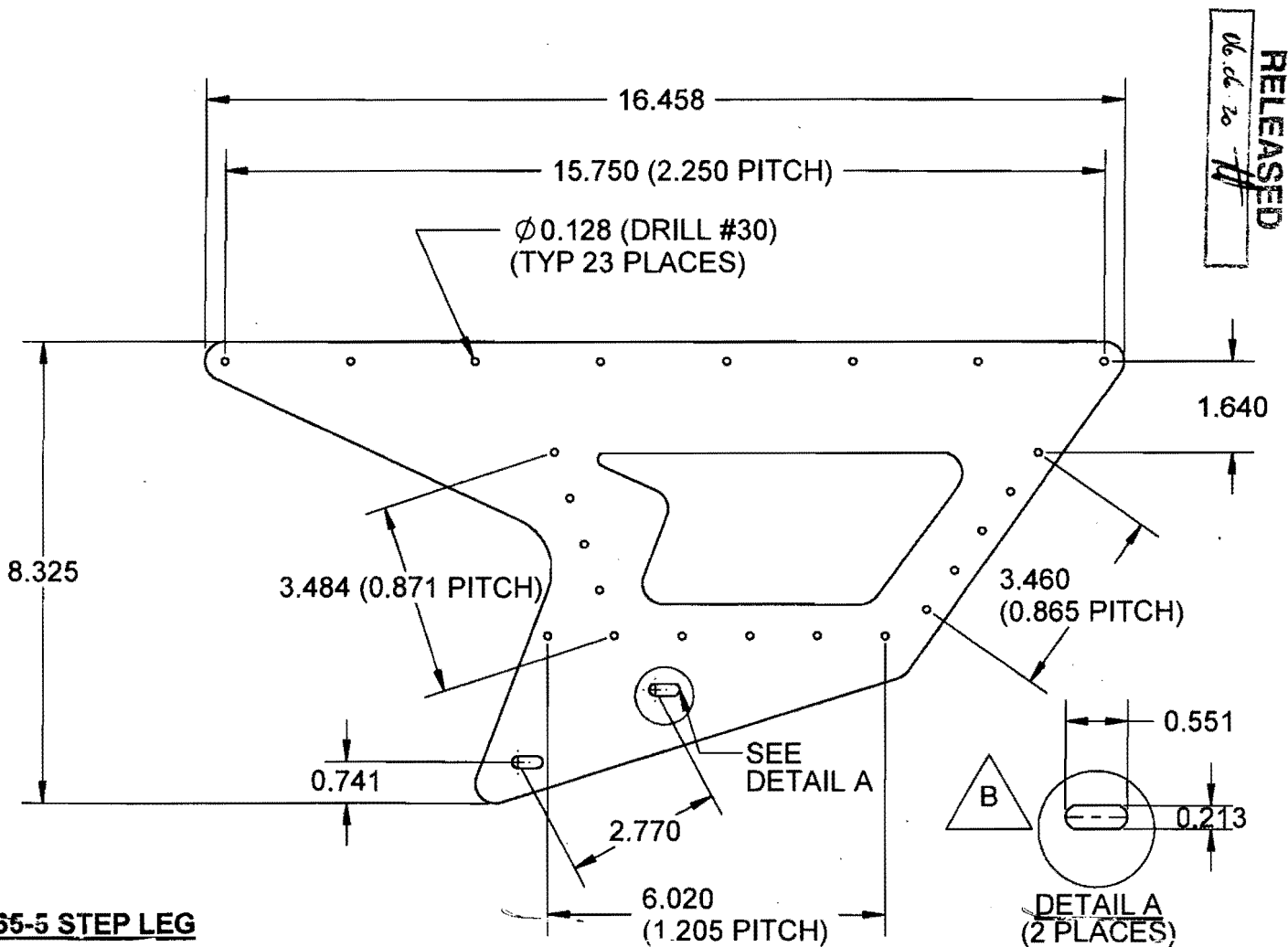
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.458	X		T H301	
15.750	+/-0.005	15.750	X		T	
2.250	+/-0.005	2.252	X		V H302	
3.460	+/-0.005	3.461	X		V	
0.865	+/-0.005	.866	X		V	
6.020	+/-0.005	6.018	X		V	
1.205	+/-0.005	1.204	X		V	
3.484	+/-0.005	3.484	X		V	
0.871	+/-0.005	.873	X		V	
8.325	+/-0.010	8.326	X		PROWIS 02	
0.551	+/-0.010	.549	X		V	
0.213	+0.005/-0.000	.214	X		V	
Ø0.128	+0.005/-0.000	.131	X		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-3-21	Date: 11/07/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
PH	<i>[Signature]</i>	D3065	SHEET 4 OF 5
DATE	TITLE		
06.05.23	STEP LEG ASSEMBLY		
		SCALE	1:3



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
- 4067222

4067222

COPYRIGHT ©2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries